

## WHAT IS CLAIMED IS:

1. A flexible storage tank, which comprises:

a plurality of panels, each of the panels bonded by lapped seams with others of the panels to enclose a storage volume, the panels being of appropriate size and shape to load all of the lapped seams predominantly in shearing stress when the storage volume contains a liquid.

2. The flexible storage tank of Claim 1, which includes a plurality of rounded corners, each of the corners including at least four of the panels.

3. The flexible storage tank of Claim 1, in which one of the panels includes a cutout and is attached to a manway having a removable cover for closing the cutout.

4. The flexible storage tank of Claim 1, in which each of the panels is composed of a thermoplastic material and a fabric layer.

5. The flexible storage tank of Claim 1, in which each of the panels is thermally bonded each of the panels bonded by lapped seams with others of the panels.

6. The flexible storage tank of Claim 1, in which each of the panels is composed essentially of urethane and a fabric layer.

7. A flexible storage tank, which comprises:

a plurality of panels, each of the panels bonded by lapped seams with others of the panels to enclose a storage volume; and

a plurality of rounded corners, each of the corners including at least four of the panels.

8. The flexible storage tank of Claim 7, in which each of the corners includes a generally triangular panel that is bounded by three curved edges, each of the curved edges being bonded by one of the lapped seams with one of the other panels.

9. The flexible storage tank of Claim 8, in which each of the panels that is bonded with one of the triangular panels is bonded to two others of the panels that are bonded to the same one of the triangular panels.

10. The flexible storage tank of Claim 9, in which each of the panels that is bonded with one of the triangular panels is bonded, respectively, to another of the triangular panels.

11. The flexible storage tank of Claim 9, which has a length, and in which the panels extend generally lengthwise, specifically excepting the triangular panels.

12. The flexible storage tank of Claim 7, in which each of the corners is generally ellipsoidal when the storage volume contains a liquid for storage.

13. The flexible storage tank of Claim 7, in which each of the panels is appropriately sized and shaped to load all of the lapped seams predominantly in shearing stress when the storage volume contains a liquid.

14. The flexible storage tank of Claim 7 in which one of the panels includes a cutout and is attached to a manway having a removable cover for closing the cutout.

15. The flexible storage tank of Claim 7, in which each of the panels is composed of a thermoplastic material and a fabric layer.

16. The flexible storage tank of Claim 7, in which each of the panels is thermally by lapped seams with others of the panels.

17. A method of making a flexible storage tank having rounded corners, which method comprises:

shaping generally rectangular top panels, each of the top panels being of about the same length as the other top panels;

shaping generally rectangular bottom panels, each of the bottom panels being about the same lengths as the other bottom panels;

shaping side panels, each of the side panels having a length that is less than the length of the top panels and less than the length of the bottom panels;

shaping generally triangular panels, each of the triangular panels being bounded by three curved edges;

bonding the top panels to each other;

bonding the bottom panels to each other;

bonding each of the side panels, respectively, to one of the top panels and one of the bottom panels to produce a tube;

bonding each of the ends of the top panels, respectively, with one of the ends of the bottom panels; and

bonding each of the curved edges with one of the top panels, one of the bottom panels or one of the side panels to produce a flexible storage tank having rounded corners.

18. The method of Claim 17, which includes bonding of the rectangular panels to others of the panels by lapped seams.

19. The method of Claim 18 in which the panels are composed essentially of a thermoplastic material and a fabric layer, and the method includes thermally bonding the panels to each other.

20. The method of Claim 19, which includes sealing the edges of the panels with a rubber gum.